

# Work Order ID 110030

December-17-13 9:06:34 AM

\*110030\*

Page 1

Item ID: D2803-2

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 12/17/13 Start Qty: 6.00

\*5\*  
\*6\* \*7\*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: H Date: 13-12-17 Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2803	Rev B

100 0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per File d2803-2\_blank

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

6061 .500 x 10.00"

7 0 de  
14-02-18

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA102

7 0 de  
~~14-02-18~~  
M4 14/03/11

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

7 0 de  
M4 14/03/11

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Page 2

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Accept

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Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 12/17/13 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

145

QC7-Inspect Chemical Conversion Coat

0.00

\*145\*

QC

Memo

0.00

Quality Control

B. A 14/03/13

7

0

DAS  
08  
9-89

7

7/6/13/14

7x

14/03/18  
DAS  
36  
8-89



# Work Order ID 110030

\*110030\*

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December-17-13 9:06:34 AM

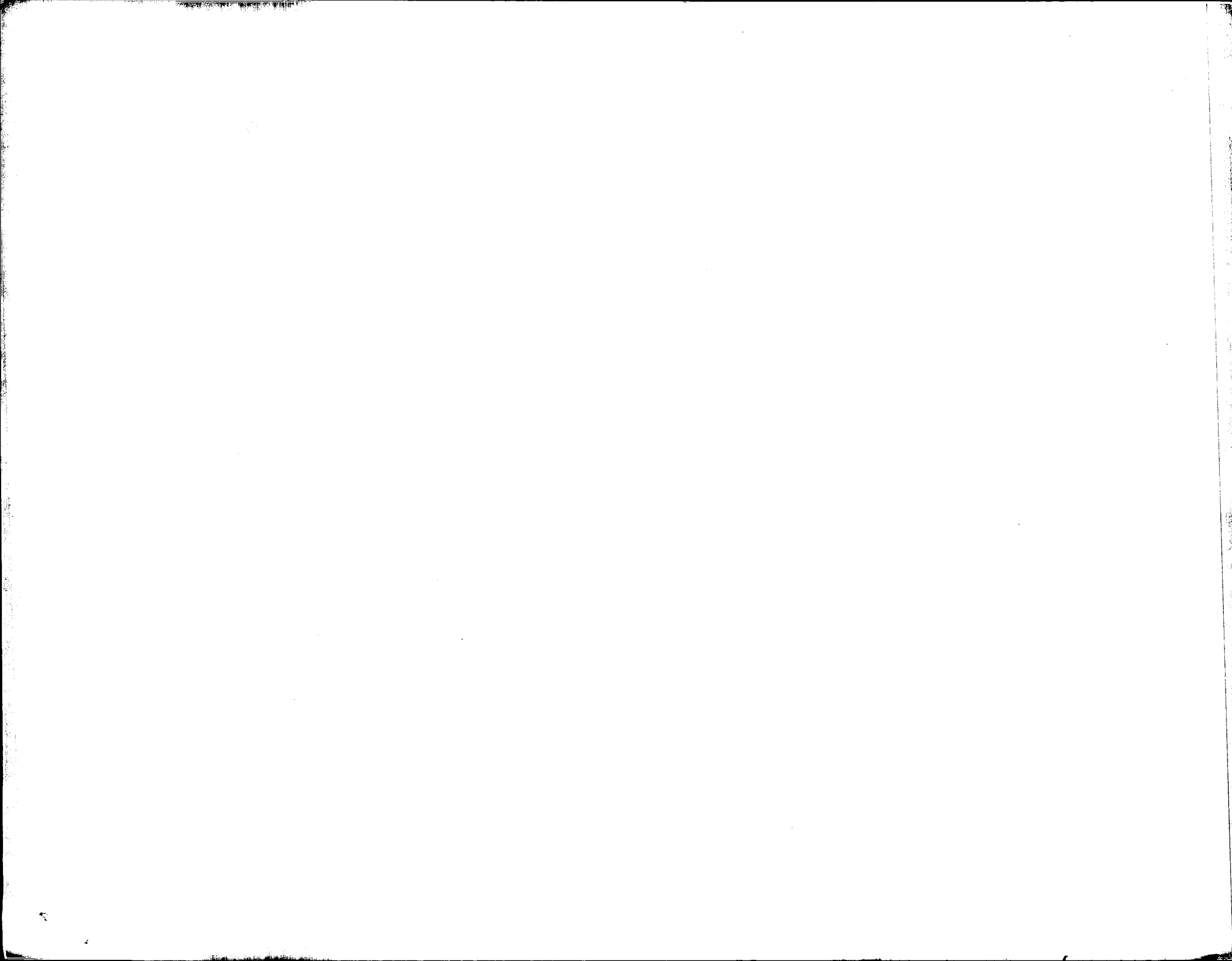
Item ID: D2803-2 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket  
 Start Date: 12/17/13 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>G-A</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00				7x			14/03/18
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							14-03-18
Quality Control									

14-03-18

DAS  
36  
9-89



# Picklist Print

December-17-13 9:06:34 AM

Page 1

Work Order ID: 110030

Parent Item: D2803-2

Parent Item Name: Bracket

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 00.11.06New IssueEC  
 IPP Rev:B Blanks now cut on Waterjet 06-06-14 JLM  
 IPP Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC IPP Rev:D add qc3 DD  
 10.02.19 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.500X10.000

Purchased

No

100

f

57.0000

1.9167

~~12.105473~~

*Ac 14-02-18*

6061-T6 Bar .500 x 10.00

Location

Loc Qty

Loc Code

MAT005

57

M127015

8

M127180

24

M127464

25

127464 → 13.0



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	110030
<b>Description:</b> Bracket		<b>Part Number:</b>	D2803-2
<b>Inspection Dwg:</b> D2803 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype



Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.757	✓		Pin Gauge	—
1.420	+/-0.001	1.420	✓		FK-08	Caliper
Ø0.191	+0.005/-0.000	<del>0.191</del> .192	✓		1	1
Ø0.507	+0.000/-0.001	.5065	✓		Pin Gauge	—
Ø0.507 x 0.250	+0.000/-0.001	.5065 x .253	✓		Pin Gauge	—
12.411	+/-0.010	12.411	✓		CHC-02	Caliper
6.933	+/-0.010	6.934	✓		FK-08	Caliper
0.250	+/-0.010	.249	✓		1	1
0.875	+0.000/-0.001	.8745	✓		1	1
0.250	+0.000/-0.005	.254	✓		Dev mic	MH-06
0.125	+/-0.010	.123	✓		FK-08	Caliper
0.125	+/-0.010	.122	✓		1	1
0.500	+/-0.010	.502	✓		1	1
0.125	+/-0.010	.124	✓		1	1
0.188	+/-0.010	.188	✓		1	1
0.562	+/-0.010	.563	✓		1	1
0.125	+/-0.010	.123	✓		1	1

<b>Measured by:</b>	MH -	<b>Audited by:</b>	A.E. DAS	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	14/03/11	<b>Date:</b>	14/03/13 08:09	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	
C	08.01.16	Tolerance revised for 0.875 dimension	KJ/EC/DD	

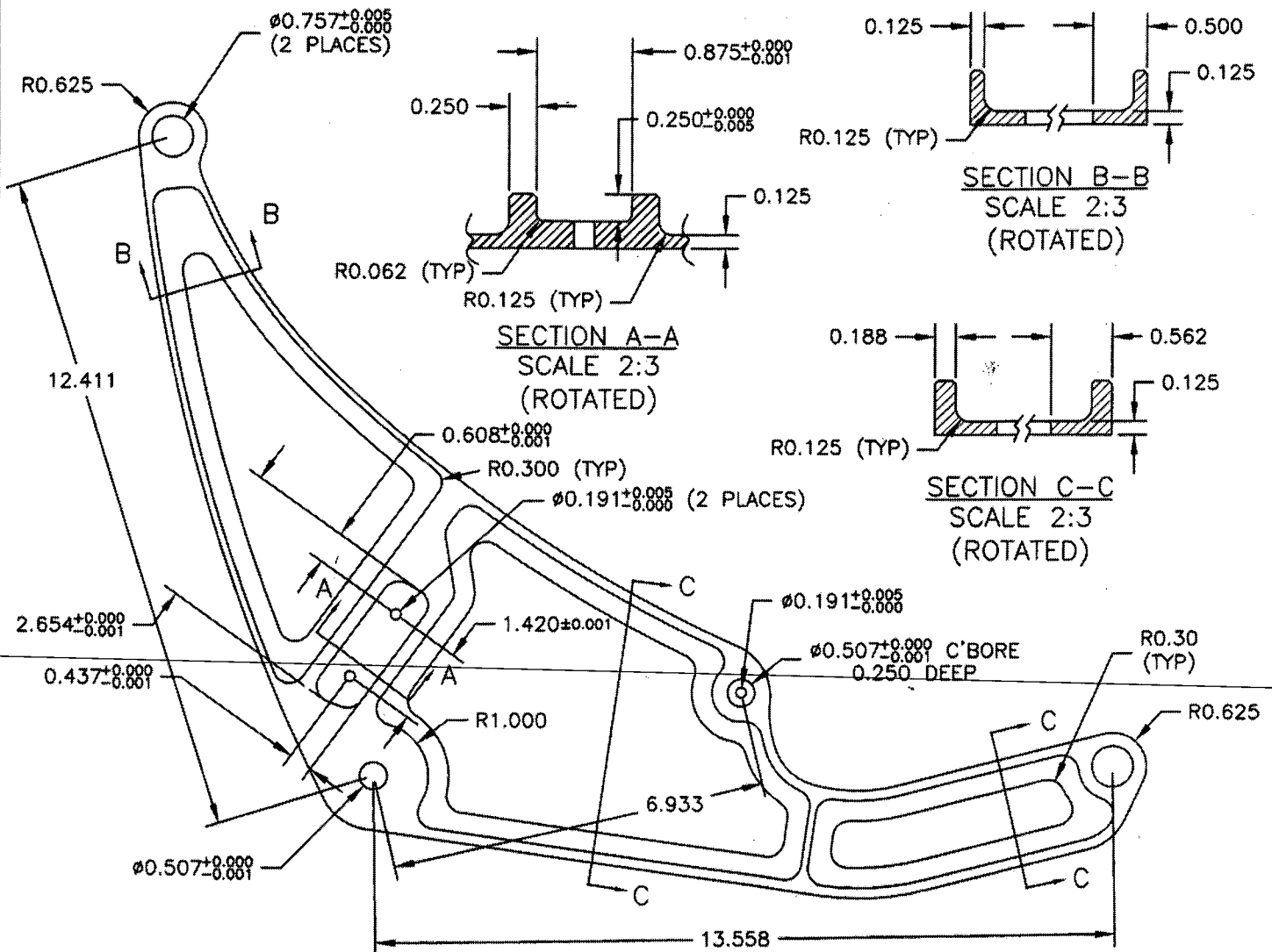




DESIGN CP		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2803 REV. B SHEET 1 OF 2	
DATE 04.11.22			TITLE STA 84 BRACKET SCALE 1:3		
A	00.11.07		NEW ISSUE		
B	04.11.22		ADD CUTOUTS & -043/-044		

**RELEASED**

05.03.11



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

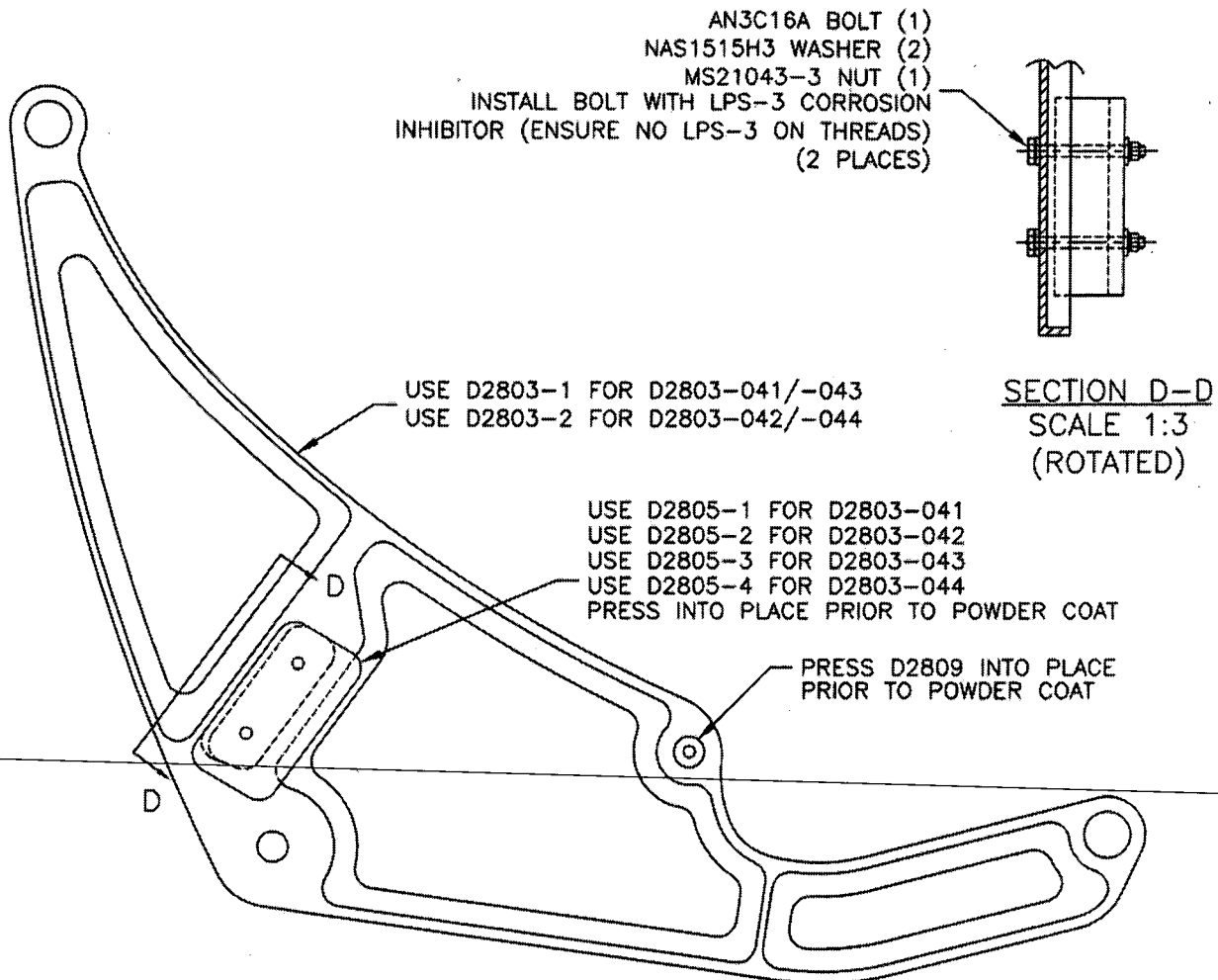
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11 [Signature]

D2803-041/-043 BRACKET ASS'Y (SHOWN),  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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